



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6795635-1
Job Sheet 196442



Part No: RB6795635-1

Job Qty: 2 pcs

DAS

Part Name: Sleeve

3 pcs

21



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 7/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6795635 Rev D IPP Rev A 17.11.29 New Issue DP Verify DD/IPP Rev. B 19.06.13 Drawing Revision
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	SL-154 - 1	2 pcs	7/26/19	7/26/19	1.00	1.00	SL-154 - 1		19/07/19
140	QC 2	2 pcs	7/26/19	7/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		19/07/19
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 86		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S198509



Part: RB6795635-1

Job No: 196442

Serial No/Batch: S198509

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 07/17/19

150 QC 8	2 pcs	7/26/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	OK 19/07/17
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
180 Outsource - 12 - Black Oxide	2 pcs	7/26/19		GRO002-VC	OK 2019-07-22
190 Packaging 2-1 - Receive - B4B	2 pcs	7/26/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	OP JUL 3 0 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Plex 6/13/19 10:43 AM Dart.lajeunesse.marie	

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
200 QC 6	2 pcs	7/26/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	81
					QC 6 - 40	9-89
						JUL 31 2019
210 Packaging 3-1 - Stock - B4B	2 pcs	7/26/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	2 pcs	7/26/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
						AUG 01 2019
Part Op 130 - MORI SL-154 LATHE - 1-Machine as per folio FB687 FOLIO REV: AA DWG REV: D 2-						
Descriptions: Deburr						
140 - QC2- Inspect parts off machine FAI/FAIB						
150 - QC8- Inspect parts - second check 1-- Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.						
180 - Issue P/O; 44067 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;						
O1 -Certificate of Conformity is required						
190 - Receive & Inspect for Damage & Mat'l Certs						
200 - QC6- All purchased or subcontracted products						

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210 - Identify as per dwg & Stock Location: _____
220 - Weld per dwg A/R 4130 rod Batch: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R1.750 <i>M4140QT R.1375</i>	4140 Round Bar 1.750	.5000 ft (.25 ea)	130-SL-154 - 1	<i>S038523</i>

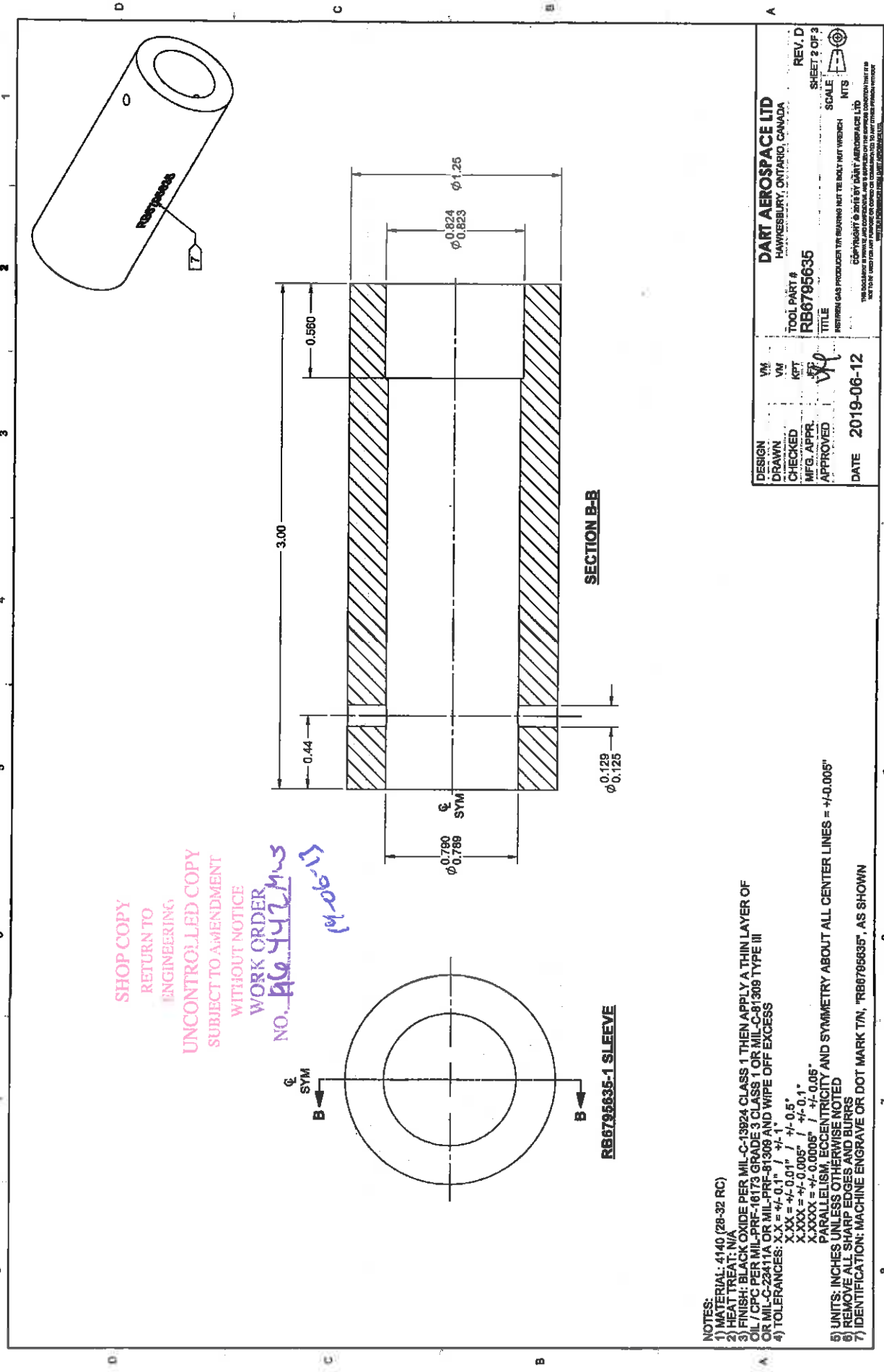
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
130-SL-154 - 1	M4140H-R1.750	1	1	0

Part Specifications

Specifications could not be found.

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SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. RB6795635-1
(14-06-11)

NOTES:
1) MATERIAL: 4140 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-91309 AND WIPE OFF EXCESS
4) TOLERANCES: XX = ± 0.01 / ± 0.1
XXX = ± 0.005 / ± 0.1
XXXX = ± 0.0005 / ± 0.06
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/M, "RB6795635", AS SHOWN

DESIGN	VM	REV. D
DRAWN	VM	SHEET 2 OF 3
CHECKED	KFT	SCALE
MFG. APPR.	W	NTS
APPROVED		
DATE	2019-06-12	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB6795635 TITLE METRON GAS PRODUCER T/M BEARING T/M TE BOLT T/M WRENCH COMPANIMENT & PART BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES FOR WHICH IT WAS ISSUED. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION FROM DART AEROSPACE LTD.		

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐
		Use-as-is ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐
			Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐
					Engineering ☐
					Water Jet ☐
					Supplier ☐
					Quality ☐
Date : _____		Sequence #: _____		QTY Affected : _____	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐		Contamination ☐		Power Loss/Surge ☐	
Manufacturing Process ☐		Misaligned/off center ☐		Folio/Program ☐	
Equip/Tooling ☐		BOM/Route ☐		Grain Direction ☐	
Handling/Preservation ☐		Broken/Damage/Defect ☐		Weld ☐	
Material ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐	
Product Improvement ☐		Drill Holes ☐		Out of Sequence ☐	
Process Improvement ☐		Fit/Function ☐		Off-set/Set-up ☐	
Human Factors ☐		Other/Details:		Positioned Wrong ☐	
				Outside Tolerance ☐	
				Drawing ☐	
				Finish ☐	
				Part Lost/Missing ☐	
				Misread ☐	

Completed By

Lead hand / Supervisor

QC / QA Coordinator



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044067



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044067

PO Date: 7/22/19

Due Date: 7/29/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pyrm Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-07-23

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196604	RBEL133M-6204-101	Puller -Issue P/O; -Black oxide finish, MIL-C-13924 Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	7/29/19	1 pcs	0 pcs	1 pcs	\$12.00/pcs	\$12.00

Line Item Note 1 kit = 3 pcs



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PURCHASE ORDER

POHB044067



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	196442	RB6795635-1	Sleeve -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed	-	7/29/19	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
3	196726	RB6795969-4	Knurl Nut -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/29/19	6 pcs	0 pcs	6 pcs	\$12.00/pcs	\$72.00
Grand Total:										\$120.00	



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PURCHASE ORDER

POHB044067



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/23/19 3:54 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020968-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020968 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc No.	Bon de commande Client Customer Purchase Order No.				
26-Jul-2019		Jigar Patel		POHB044067				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté Né Ns Qty	Qté Scrap/	À venir / Back Order
1	RBEL133M-6204-101 Rev.	RBEL133M-6204-101 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3, CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS KIT PRICE FOR 3 ITEMS	OXIDE-BLACK CH	1	1	0	0	0
2	RB6795635-1 Rev.	RB6795635-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] AS PER MIL-C-13924C, CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3, CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	BLACK-OXIDE CH	3	3	0	0	0
3	RB6795969-4 Rev.	RB6795969-4 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] AS PER MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3, CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0

**DAS
81
9-89**

RECEIVED
 JUL 30 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.